

Date: Monday, 1/7/2008 11:14:43 AM
User: Kim Johnston

Process Sheet

5

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MECHANICAL GROUND HANDLING WHEEL KIT
Job Number	: 36615B		
Estimate Number	: 12140		
P.O. Number	:	Part Number	: D206731042
This Issue	: 1/7/2008 S.O. No. :	Drawing Number	: DSK 093 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: X B
Previous Run	: 36211B	Material	:
Written By	:	Due Date	: 1/31/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>1802.01.07</u>		
Comment	: est rev. A 01.02.01 new issue EC Est Rev:B As per Rev b 07-02-13 JLM est rev C 07.05.14 rev C IIN ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33355	spring
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✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description	batch
1	D3335-5	spring	<u>B33948</u>

Pl 09-01-14

2.0	D3353042	LUG ARM WELDMENT
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✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description	batch
1	D3353-042	LUG ARM WELDMENT	<u>B37787</u>

Pl 09-01-14

3.0	D3354042	MIRROR ARM WELDMENT
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✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

qty	Part Number	Description	batch
1	D3354-042	Left Arm Weldment	<u>B36214</u>

Pl 09-01-14

4.0	D3354043	RIGHT ARM WELDMENT
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✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
RIGHT ARM WELDMENT

batch: B42477

Pl 09-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33561

pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	<u>B30389</u>

Plc 09-01-14

6.0

D3397041

wheel ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	<u>B34623</u>

Plc 09-01-14

7.0

113800

GREASE FITTING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	<u>M109604</u>

Plc 09-01-14

8.0

656051

flat washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	<u>M105735</u>

Plc 09-01-14

9.0

663079

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	<u>M16362</u>

Plc 09-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN523A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty Part Number Description batch

1 AN5-23A Bolt

M19278

Pl 09.01.14

11.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty Part Number Description batch

1 AN960JD516 Washer

M109752

Pl 09.01.14

12.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty Part Number Description batch

2 CP-21 1/8" Cotter Pin 2" long

M168200

Pl 09.01.14

13.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty Part Number Description batch

1 MS21042L5 Nut

M109297

Pl 09.01.14

14.0

SNF34

SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty Part Number Description batch

1 SNF-34 SLOTTED NUT

M109706

Pl 09.01.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D206731042

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description
1	TP-2	Spring pin

batch

M16588

Pl 09-01-14

16.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description
1	TP-134	Spring pin

batch

M16362

Pl 09-01-14

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

Pl 09-01-14 / SAO 09-01-14

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAO 09-01-14 @

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Pl 09-01-15

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15

Job Completion



U 09-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

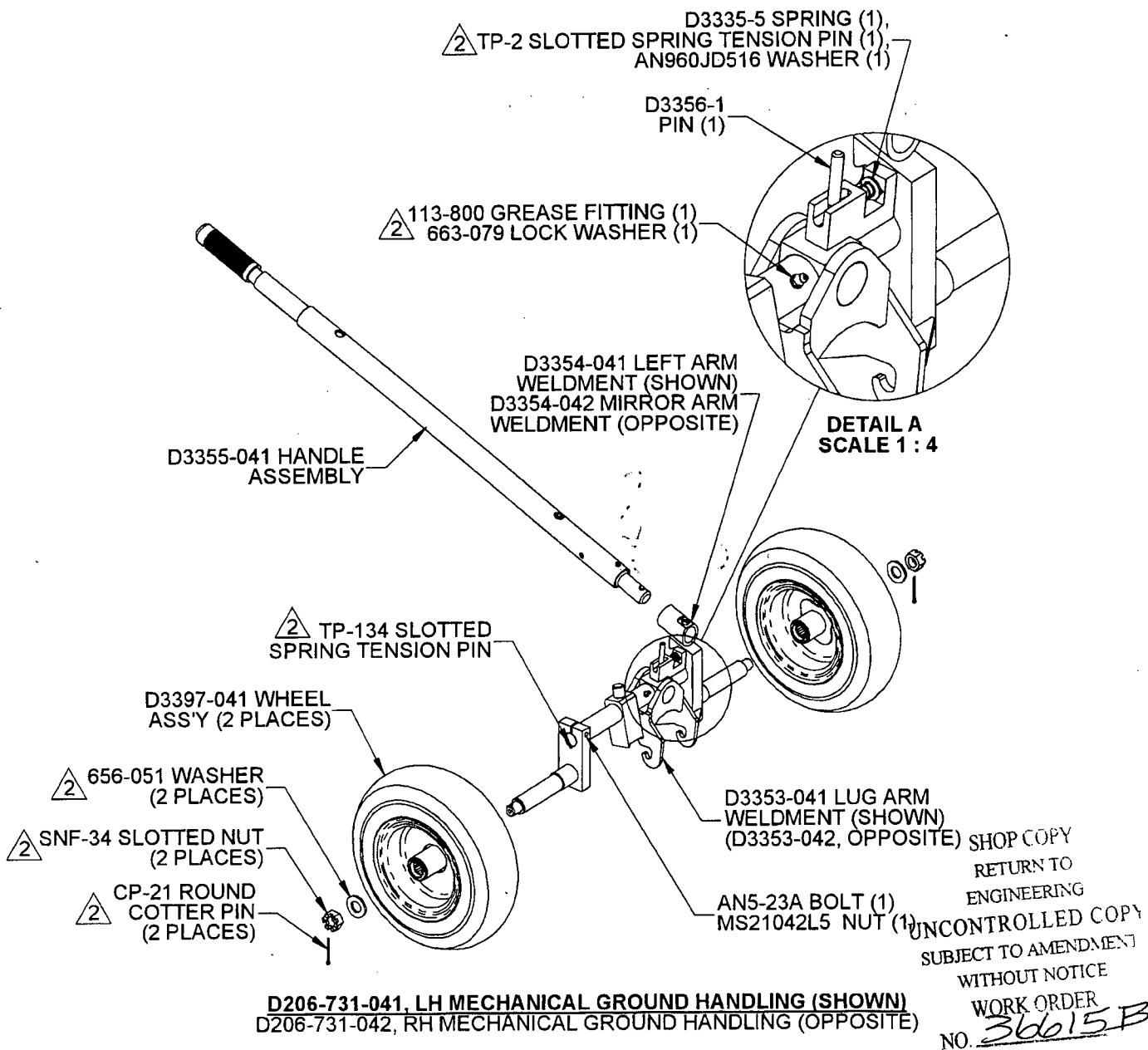
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.02.05

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02		TITLE MECH. GROUND HANDLING	SCALE 1:10
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAUER.

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